



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3317-20
Job Sheet 197461



Part No: RBE350A93-3317-20

Job Qty: 18 pcs **20**

Part Name: Tail Rotor Hub Insert Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/9/19

Job Tracking No:

Due Date: 9/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3317-20 REV: 1B IPP REV: A 18.01.15 NEW ISSUE RQ VERIFIED BY: DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	SL-2500Y - 1	18 pcs	9/2/19	9/2/19	1.00	1.50	SL-2500Y - 1		SL 19-7-24
130	QC 2	18 pcs	9/2/19	9/2/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		SL
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

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140 QC 8	18 pcs	9/2/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	8/19-08-07
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
170 Outsource - 12 - Black Oxide	18 pcs	9/2/19		-MEM001-VC	8/2019-08-15
180 Packaging 2-1 - Receive - B4B	18 pcs	9/2/19	0.00 0.00	Packaging 2 - 1 - B4B	
208 pcs.				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	8 AUG 22 2019
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	

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				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
185 QC 6	18 pcs	9/2/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	DAS
				QC 6 - 40	81
				QC 6 - 81	9-89
190 Packaging 3-1 - Stock - B4B	18 pcs	9/2/19	0.00 0.00		AUG 22 2019
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - FG	18 pcs	9/2/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	AUG 27 2019
				QC 21 - SA - 53	

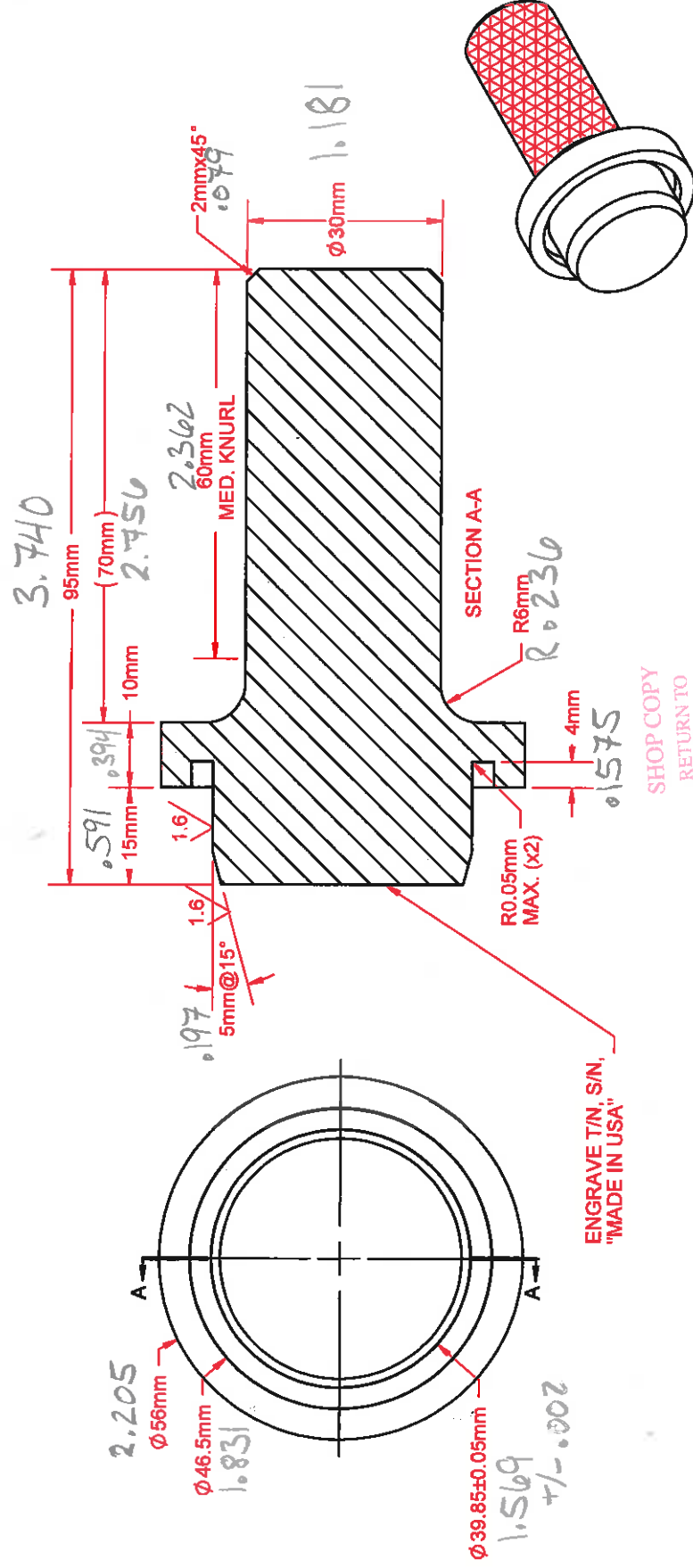
Part Op 120 - (MORI SL2500Y LATHE) 1-Machine as per folio FB742 FOLIO REV: AA DWG REV: B 2-
Descriptions: Deburr Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.
130 - (QC2- Inspect parts off machine FAI/FAIB)
140 - (QC8- Inspect parts - second check)
170 - Issue P/O to Groupe Altech; PO 44272 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of
Conformity is required
180 - (Receive & Inspect for Damage & Mat'l Certs)
185 - (QC6- All purchased or subcontracted products)
190 - (Identify as per dwg & Stock Location:)
210 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R2.250	AISI 4140 Quenched & Tempered Steel Round Bar 2.250" Dia.	5,8500 ft (.325 ea)	120-SL-2500Y - 1	5177998
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-SL-2500Y - 1	MT-4140QT-R2.250	6	9	0
Part Specifications				
Specifications could not be found.				

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	DESIGNED PER HELI PRODUCTS TOOLS	9/28/09	WP	DW
1A	ADDED ENGRAVE NOTE & 70mm REF. DIMENSION.	10/4/11	RJC	DW
1B	CH'D T/N WAS RBEA93-3317-20 IS RBE350A93-3317-20.	11/6/13	RJC	RW

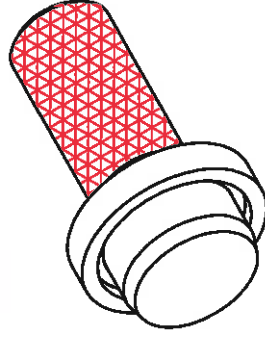


SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

NOTE:
1. CENTERS OK.

WITHOUT NOTICE
WORK ORDER
NO. 197461 M5
1907-05



RED BARN MACHINE

TITLE TAIL ROTOR HUB INSERT TOOL

1407

DWG NO.				RBE350A93-3317-20		REV	1B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES				DRAWN BY:		PERRITT	
				APPROVED			
TOLERANCES ON:				METRIC ±0.1		HEAT TREAT	
				DECIMALS ±.005		FINISH	
XX ±.01				FRACTIONS ± 1/32		BLACK OXIDE	
				ANGLES ±5°		USED ON MODEL	
X ±.1				UNLESS OTHERWISE SPECIFIED		EUROCOPTER	
				1. BREAK ALL SHARP EDGES			
2. DIMENSIONAL LIMITS APPLY AFTER PLATING				.015 ± .45 FR .016 R			
SCALE				DATE		SHEET	
NTS				9-28-09		1 of 1	



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB044272



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044272
PO Date: 8/15/19
Due Date: 8/23/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197183	RB6872882-1	Adjusting Screw -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/23/19	4 pcs	0 pcs	4 pcs	\$2.35/pcs	\$9.40

4 X AUG 22 2019

5199376

Plex 8/16/19 9:01 AM Dart.Guerin.Kimberley

https://www.plexonline.com/25f172b4-d07e-42d6-aedd-e8256207741c/Plexus_Control/Report_Viewer_2.asp?rv=u%1E..%2FPurchasing%2FPO_Print... 1/4



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PURCHASE ORDER

POHB044272



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	196746	RBW109-3130-53-113-3	Pin -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	8/23/19	12 pcs	0 pcs	12 pcs	\$2.35/pcs	\$28.20
12 X AUG 22 2019 [Signature]											
5203982											
3	197461	RBE350A93-3317-20	Tail Rotor Hub Insert Tool Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/23/19	20 pcs	0 pcs	20 pcs	\$5.41/pcs	\$108.20
20 X AUG 22 2019 [Signature]											
5200134											
4	199087	RBE350A93-3303-02-3	Extractor Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/23/19	19 pcs	0 pcs	19 pcs	\$2.65/pcs	\$50.35



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PURCHASE ORDER POHB044272



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	198324	RBW6521A00138-W142AH-3T-3	Top Brace -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/23/19	4 pcs	0 pcs	4 pcs	\$3.70/pcs	\$14.80
4 X AUG 22 2019 [Signature]											
5204894											
6	199075	RBST2120-15	Locating Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/23/19	5 pcs	0 pcs	5 pcs	\$2.35/pcs	\$11.75
5 X AUG 22 2019 [Signature]											
5205486.											
7	199077	RBST2120-9	Pin Outsource12 (Outside Processing - Black Oxide) Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/23/19	5 pcs	0 pcs	5 pcs	\$0.95/pcs	\$4.75
5 X AUG 22 2019 [Signature]											
5205338.											



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PURCHASE ORDER

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Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	197189	RB6872882-9	Handle Weldment Outside Processing - Black Oxide -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	8/23/19	3 pcs	0 pcs	3 pcs	\$0.95/pcs	\$2.85
3 X AUG 22 2019											
S 205327											
Grand Total:											\$230.30

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/16/19 9:01 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance
(021617-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip
021617- 1

Livré à / Ship to
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
21-Aug-2019		Jigar Patel		POHB044272 ✓				
# ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RB6872882-1 Rev.	RB6872882-1 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS MAT TYPE; 4140	OXIDE-BLACK CH	4	4 ✓	0	0	0
2	RBW109-3130-53-113-3 Rev.	RBW109-3130-53-113-3 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS MAT TYPE; 1018	OXIDE-BLACK CH	12	12 ✓	0	0	0
3	RBE350A93-3317-20 Rev.	RBE350A93-3317-20 01-BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	20	20 ✓	0	0	0
5	RBW6521A00138-W142AH-3T-3 Rev.	RBW6521A00138-W142AH-3T-3 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS MAT TYPE; 4140	OXIDE-BLACK CH	4	4 ✓	0	0	0
6	RBST2120-15 Rev.	RBST2120-15 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	5	5 ✓	0	0	0
7	RBST2120-9 Rev.	RBST2120-9 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	5	5 ✓	0	0	0
8	RB6872882-9 Rev.	RB6872882-9 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS MAT TYPE; 1018	OXIDE-BLACK CH	3	3 ✓	0	0	0

RECEIVED
AUG 21 2019
DART AEROSPACE LTD.

**Certificat de Conformité / Certificate of Compliance**
(021617-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupealtech.com

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Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
21-Aug-2019		Jigar Patel				POHB044272				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #		Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual ThicknessInspecteur Qualité
Quality InspectorRéçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.